Work Order ID 96831

Memo

February-07-13 8:23:26 AM

Quality Control

Ship March 25

Revision ID:	D3933-2 Aft Cabin Wa	ll Protector. RH		Accept	*N900	040	100)*	•	start Stop	_	S1* S2*	
Start Date: Required Date: Reference:	2/07/13 3/22/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item 1 Customer:	D:		•		•	"IN	57"	
Approvals:	Process Pla	an: MCZ	Date:							Start Stop		R1* R2*	
Sequence ID/ Work Center ID	- <u>-</u> .	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reject Qty		Reject Tumber	Insp. Stamp	
Draw Nbr	Rev	ision Nbr	·			:							
D3933	A												
100				0.00			-						
100 Waterjet FLOW CNC Waterjet		Memo I-Cut as per I Dwg Rev: Prog Rev:	A	0.00				12				Jm13-2	-21
		2- Deburr if n	necessary										
*110 *110*		QC2- Inspect parts off ma	chine FAI/FAIB	0.00				12	0		, .	Jm 13-2	L-Z

0.00

											DQA:	Date	:
NCR: Y	⁄es	/ No				WORK ORDER NON	-CO	NFORI	MANCE / UPDATE		QA Closed:	Date	:
Monte Ond			, t- =			DISPOSITION	***		AGAINS	ST DE	PARTMENT/	PROCESS	
Work Orde Part N	No.					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Crosstub Machining Small Fa noforming Finishir Large Fab Composi	nb	1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descr	iption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	c	hief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling				i									
Operator	П						- [Ì
Material			1				1						
Setup	П			1 1									
Other	Г												
Process													
Supplier					!								
Training					:								
Unapproved		1											
							FAU	ILT CATE	GORY				
Landi	ing (Gear				General							
	Ť	Bending				Bend	Γ	Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	arė		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	Γ	Inspect	tion Incomplete		Part Incorred	ct [Weld
		Crushed	/Crimped			Burrs		Instruc	tions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs	•			Contamination			eriance		Part Moved	_	
		Heat Tre	at		T	Countersink		Mislab	eled		Positioned V	Vrong	_
	\vdash	4	on Strip ir	n Tube	<u> </u>	Cut Too Short		Misrea	d		Power Loss/	Surge	Other
		Ripples i	,		 	Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

February-	07-13	8:23:26	AM

D3933-2

Accept *N900040100*

Setup Start *NIC1*

Item Name: **Start Date:**

Revision ID:

Item ID: .

Aft Cabin Wall Protector, RH

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 3/22/13

Process Plan:

Date:

Tooling:

Date:

Run

Page 2

2/07/13

Date: SPC (Y/N):

Date:

Sequence ID/ **Work Center ID**

Operation **Description**

Set Up/ Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject Otv

Reject Insp. Number Stamp

120

120

Memo

QC8- Inspect parts - second check

Quality Control

13221

130

Identify as per dwg & Stock Location: \$\int \text{0.00}\$

130

Packaging Packaging

Memo

140

QC21- Final Inspection - Work Order Release

0.00

140

Memo

0.00

Quality Control

											DQA:	Date:	
NCR: Y	⁄es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE	QA Closed:	Date:	
		-				DISPOSITION				AGAINST DE			
Work Orde Part N	No. _.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Acti	on	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							FAU	LT CATE	GORY				
Landi	ing (Bending Centre N Cracks Crushed, Cuffs Heat Tre	/Crimped		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct	ion Incomplete tions Incomplete/U enance eled	Inclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	1	Ripples i	n Bend		1	Drill Holes	L	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Picklist Print

February-07-13 8:23:29 AM

Work Order ID: 96831

96831

Parent Item:

D3933-2

D3933-2

Parent Item Name: Aft Cabin Wall Protector, RH

Start Date: 2/07/13

Required Date: 3/22/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prima Item Locati	on Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date S Issued	Status
MLEXS.125-F60029-04	-	Purchased	No		100	sf	11.6273	7.01	-84.12	<u>-</u>		
*MI FXS 1		N29-N4	*					**	128		<u>.</u>	5m13-2

GE PLASTICS LEXAN SHEET

Location Loc Qty Loc Code MAT019 11.6273 11.6273

124654

124654

Date: DQA: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: AGAINST DEPARTMENT/PROCESS DISPOSITION Work Order: Crosstube Water Jet Engineering Rework Skid-tube Prod. Eng. Coor. Quality Machining Small Fab Scrap Part No. Rec/Store/Packaging Other Use-as-is Thermoforming Finishing Supplier Work Order Update Large Fab Composite NCR No. Description of work order update Action Sign & Initial Root QC Inspector **Chief Eng** Description Date Verification or Non-conformance Step Qty Date Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training

				_					1
	Bending		Bend		Grain		Ovalized		Pressure/Forced
	Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure
Γ	Cracks	Г	Broken/Damaged		Inspection Incomplete		Part Incorrect	<u></u>	Weld
	Crushed/Crimped		Burrs		Instructions Incomplete/Unclear	_	Part Lost/Missing	L	Wrong Stock Pulled
	Cuffs	Г	Contamination		Maintenance		Part Moved		
	Heat Treat	Г	Countersink		Mislabeled		Positioned Wrong		•
	Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge		Other
Γ	Ripples in Bend		Drill Holes		Offset				
	Torque Waves in Extrusion		Drawing		Out of Calibration				
	Turning Sequence		Finish		Out of Sequence				
	Wave/Twist in Tube		Folio		Outside Dimensions				

FAULT CATEGORY

General

Unapproved

Landing Gear

DART AEROSPACE LTD	Work Order:	96831
Description: Aft Cabin Wall Protector, RH	Part Number:	D3933-2
Inspection Dwg: D3933 Rev: A		Page 1 of 1

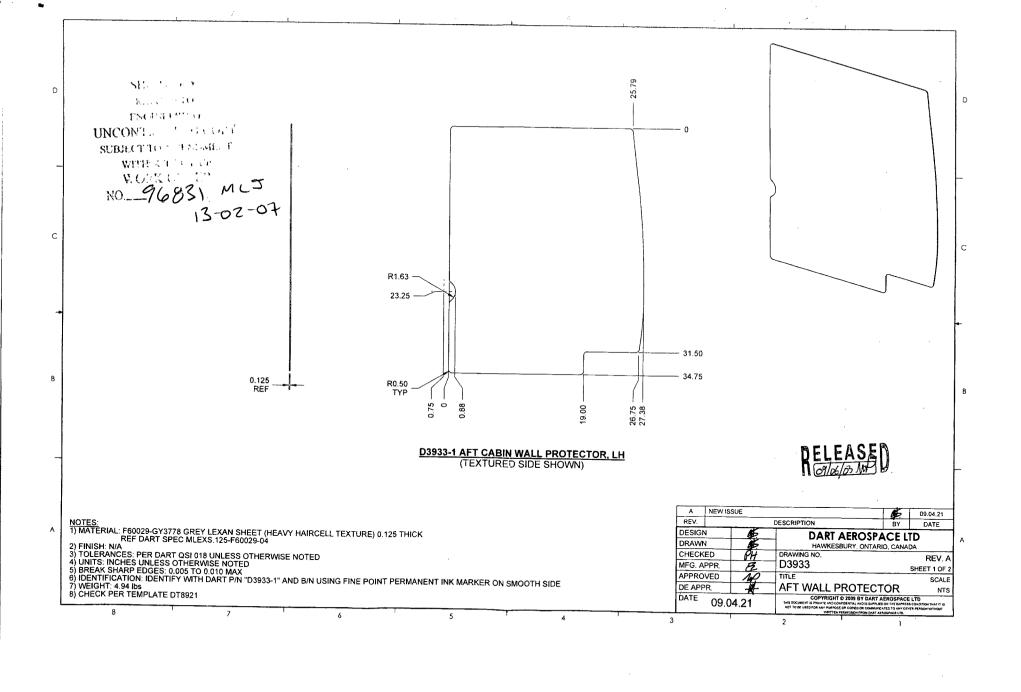
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0.88%	-		V	Jkmoi
19.00	+/-0.030	19.00	_		T	Tienos
26.75	+/-0.030	26.75	_		T	
27.38	+/-0.030	27.384	-		T	
34.75	+/-0.030	34.75"			Υ	
31.50	+/-0.030	31.50'1	-		1	
25.79	+/-0.030	25.79	-		T	
0.125	+/-0.010	0.126	_		V	·
23.25	+/-0.030	23.25			Т	
						,
 	1		Can h ci			

Measured by: Jm	Audited by:	Prototype Approval:	N/A
Date: 13-2-21	Date: 13 3	Date:	N/A

Rev	Date	Change	Revi	sed b) V	Apple	oved
Α	09.06.22	New Issue	KJ	d		1	



96831 D С - R1.63 23.25 31.50 -34.75 -0.125 R0.50 TYP REF 27.38 19.00 0.88 D3933-2 AFT CABIN WALL PROTECTOR, RH (TEXTURED SIDE SHOWN) NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04 REF DART SPEC MLEXS.125-F60029-04

2) FINISH: NIA

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3933-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE

7) WEIGHT: 4.94 lbs

8) CHECK PER TEMPLATE DT8921

DESIGN	/\$	DART AEROSPACE L	TO
DRAWN	# 5	HAWKESBURY, ONTARIO, CANA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	星	D3933	SHEET 2 OF 2
APPROVED	140	TITLE	SCALE
DE APPR.	#	AFT WALL PROTECTOR	NTS
DATE 09.0	4.21	COPYRIGHT © 2009 BY DART AEROSPAC THIS DOCUMENT IS PRIMATE AND CONTRIBUTION AND IS SUPPLIED ON THE EXPRES NOT TO BE USED FOR ANY PRIPOSE OR COPIED OF COMMUNICATED TO ANY OT	TO COMPONENT THAT IS IN